

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016071**Date Inspected:** 08-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Min.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 6:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: WJF-0-021 and 022. The welder is identified as 057795 and was observed welding in the 2G position. ZPMC Quality Control (QC) was identified as Huang Min. The welding variables recorded by QC appeared to comply with WPS: B-T-3312-TC-P5.

The SMAW process on weld joint no: WJF-0-023. The welder is identified as 053753 and was observed welding in the 2G position. ZPMC QC was identified as Huang Min. The welding variables recorded by QC appeared to comply with WPS: B-T-3312-TC-P5.

This QA Inspector observed ZPMC personnel performing the heat straightening operation on Side Panel SP3094A. The Heat Straightening was performed according to Heat Straightening Request (HSR) no: HSR1(B)-8988 Rev-0, Dated: 08/05/10. The ZPMC QC is identified as Shu Yang Hua. HSR was performed to correct the weld distortion on the Side Panel. See attached photo for further details.

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Bay 7:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SP3126-001-033 to 040. The welders were identified as 204342 and 217185 and were observed welding in the 2F position. ZPMC QC was identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

The FCAW process on weld joint no's: SP3140-001-001 to 010. The welders were identified as 204342 and 217185 and were observed welding in the 2F position. ZPMC QC was identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

The FCAW process on weld joint no's: SP3142-001-001 to 010. The welders were identified as 204342 and 217185 and were observed welding in the 2F position. ZPMC QC was identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

Bay 8:

This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: BK004A1-064-009 (after back - gouging). The welder is identified as 040831 and was observed welding in the 1G position. ZPMC QC was identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2. See attached photo for further details.

The SAW process on weld joint no: BK004A1-063-009 (after back - gouging). The welder is identified as 040831 and was observed welding in the 1G position. ZPMC QC was identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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